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SPLIT

SART AEROSPACE LTD	Work Order:	19666
Description: Fwd Crosstube	Part Number:	D2889
Drawing: D2889 Rev. B; D6005 Rev. A	Qty:	1

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg. not required RF 02.11.05	JH	03.09.19	19
2	PG	Issue P/O: a) Extrude as per Dwg D6005 length = 180" (Ref. D6005-180) b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) Seamless aluminum tube c) Minimum ultimate tensile strength = 77ksi d) Minimum tensile yield strength = 66ksi e) Material certification required		03.09.22	19
3	RG	Receive and inspect for transit damage Ensure material certification attached	DP	04-01-05	22
4	QC6	Inspect dimensions as per Dwg D6005 and check 180" length	AB	04.02.11	22 PTC
5	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube	Z	04.02.11	22
6	LG	Bend as per Dwg D2889 and Folio FT001 Sign Page 2	DP	05/3/09	1
7	QC6	Inspect dimensions per Dwg D2889 Sign Page 2	See Drawing		
8	LG	Deburr and Polish Sign Page 2	DP	05/3/09	1
9	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube Sign Page 2		N/A	
10	QC5	Inspect work to Step 9 Sign Page 2	DP	practiced several	
11	ST	Identify and stock	DP	05/3/09	1
12	AC	Cost / part: 1589.24	DP	05/06/21	1
13	DC	Close W/O 738977 Inspect Level 21	KJ	05.07.06	1

Rev	Date	Change	Revised By	Approved
A	09.05.31	New Issue, ECN 200	DM	
B	00.04.11	Remove Painting step	EC	
C	02.10.18	Re-format; Added spec	KJ	RF

RELEASED
02/01/2020 RF



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TELEFAX

Date: 05.03.09

To: Eagle Copters Maintenance Ltd.

Attention: David Shepherd

Fax Number: 1 403 717 1288

From: Roberto Fuentes

E-mail: robertof@dartaero.com

Subject: Approve dim for D205-596-105

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Hi David,

Please check this dimensions for D205-596-105 (D2889) B19666 # H.

Dwg dimensions

32.5	109.4
<u>Height</u>	<u>Span</u>
32.5	109 - 7/8
32.4	109 - 11/16
32.3	109 - 5/8
32.2	109 - 7/16

CUT HERE
ACCEPTABLE deviation on WIDTH
 05-03-10

Thanks,

Roberto